

ABSTRACT OF THE DISCLOSURE

A hole forming tool has a main body constructed of a cemented carbide comprising 10 ± 2 wt% Co, 0.65 ± 0.25 wt% Cr, WC for the balance, and inevitable impurities. The average particle diameter of WC is in the range of 0.1 to $1.0 \mu\text{m}$, and a radial rake angle of cutting edges formed at the end of the hole forming tool is set to a negative value in the range of -5° to -10° . Chip discharging grooves of which the helix angle is in the range of 5° to 15° are formed in the exterior surface of the hole forming tool. A groove width ratio of land portions and the chip discharging grooves is in the range of 0.9 to 1.1. A point angle is in the range of 125° to 135° , and a core diameter is in the range of $0.38D$ to $0.42D$, in which D is the outside diameter of the drill. The main body of the hole forming tool is coated with a TiAlN layer.

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